

ABSTRACT

A tool T such as a drill, a reamer or an end mill, formed with a through hole extending along an axis O is 5 mounted to a tool holder 10. A pressurized gas, at 1.5 to 5 MPa, is supplied to the through hole by way of the tool holder 10, and deep-hole machining is carried out while the pressurized gas or a machining liquid in mist form is ejected from the forward end of the tool T.